

Work Order ID 152609

Tuesday, November 01, 2016 1:33:05 PM

152609

Page 1

Item ID: D3885-1

Accept

DAS
13
9-89***N900040100***

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Standard Web

Start Date: 11/3/2016 Start Qty: 15.00

Required Date: 11/17/2016 Req'd Qty: 15.00

Reference:

20
NOV 1 5 2016
15
15

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS
21
9-89

Date:

NOV 0 1 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3885

C

0.00

108

108

Purchasing

Purchasing

Memo

Purchasing

Issue P/O: 34379

Supplier: WEJAY

Machine as per Dwg D3885

Conformity sheet required

836.61

20 NOV 2 1 2016 DAS
13
9-89

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

0.03

20x 5/16-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Work Order ID 152609***152609***

Page 2

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Cust Item ID:

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15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.05

Quality Control

USE DT10253 INSPECTION TEMPLATE

(20)

16-12-19

DAS
9
9-89

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.43

Hand Finishing

(x20)

2017/01/10

BEB

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.03

Quality Control

(20)

DD

17-1-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
SAC e BB-0				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 152609

Tuesday, November 01, 2016 1:33:05 PM

152609

Page 3

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Setup Start

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Revision ID:

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Item Name: Standard Web

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

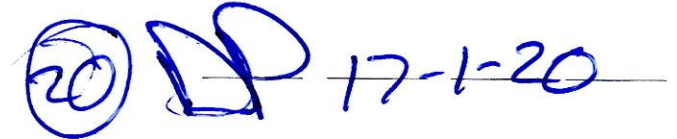
Packaging

Memo

0.03

Packaging

LOCATION: LG002



160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.25

Quality Control

DAS
21
9-89

JAN 24 2017



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
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OTHER :					

Picklist Print

Tuesday, November 01, 2016 1:33:09 PM

Page 1

Work Order ID: 152609

152609

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 11/3/2016

Required Date: 11/17/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-1P		Purchased	No				Each	0.0000		15	13		
D3885-1P									**	20		NOV 21 2016	
Standard Web													
D3882-1-130		Manufactured	No			110	Each	0.0000	1	15			
D3882-1-130									**	20			
Extrusion "I" Beam													

B/S1997

20 x 80/6-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Misaligned/off center ☐	Turning Sequence ☐																																																																			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 152609 MCT
16-11-07

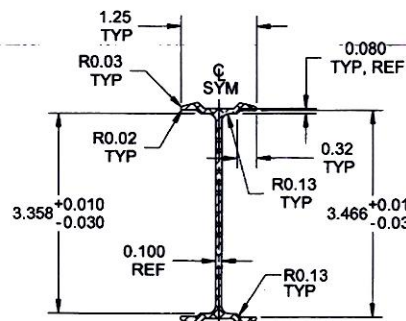
D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

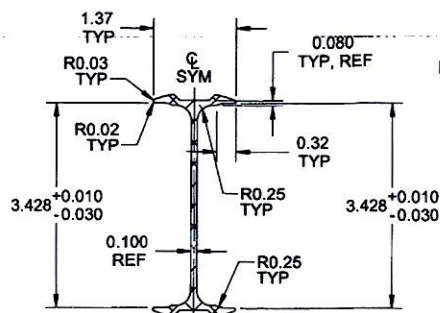
C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D3885 TITLE WEB REV. C SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	DATE 16.02.18	

RELEASED
2016-02-26
ECW 16-526

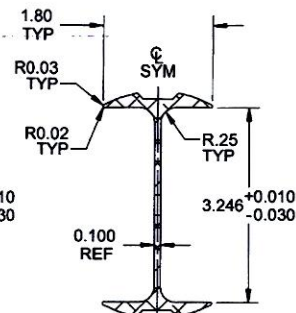
APPROVED



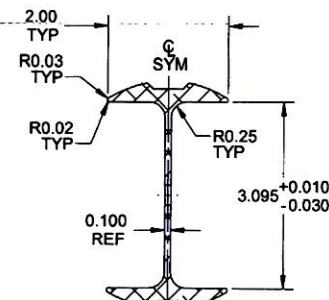
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



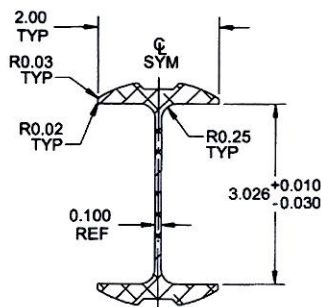
SECTION B-B
SCALE 5X
D6-2



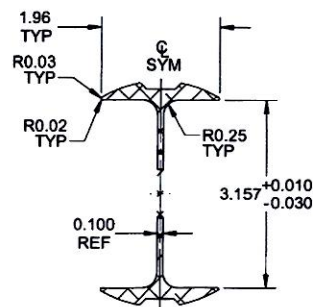
SECTION C-C
SCALE 5X
D6-2



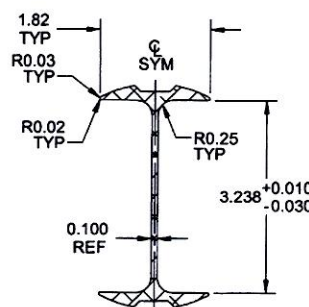
SECTION D-D
SCALE 5X
D5-2



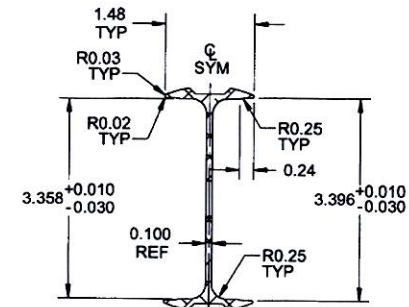
**SECTION E-E
& SECTION F-F**
SCALE 5X
D5-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2



SECTION I-I
SCALE 5X
D4-2

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D3885	REV. C
MFG. APPR.	JLM		SHEET 3 OF 5
APPROVED	HS	TITLE WEB	SCALE NTS
DE APPR.	DSC		
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34379

Purchase Order Date 11/21/2016 7:53:10 AM

PO Print Date 11/21/2016

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

NOV 21 2016

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3885-1P AS PER DWG D3885 REV. C B153347	Standard Web	11/30/2016 Yes 11/30/2016		6.00 Each	\$495.00	\$2,970.00
Line Total:							\$2,970.00
3	D3885-1P AS PER DWG D3885 REV. C B152609	Standard Web	12/15/2016 Yes 12/15/2016		20.00 Each	\$495.00	\$9,900.00
Line Total:							\$9,900.00

Note:

11/21/2016



Packing Slip 38320A
600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
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Part Aerospace
1000 Airway Street
Kingston, ON K7P 1N3

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Part Aerospace
1000 Airway Street
Kingston, ON K7P 1N3

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA		
		38320A		11/21/16		Best way		
CUSTOMER CODE		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS		
EUM								
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION				UNIT PRICE	AMOUNT
20	—	20	20 x 11.5" x 11.5" x 11.5" per dia and holes, per drawing # R-885-10 ✓ R-112-10 40000 \$/lb per December 13, 2016					
RELEASE NOTE I certify that the items listed herein have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <u><i>[Signature]</i></u>  <u>DEC 9/16</u>								
							G.S.T.	
							P.S.T.	
ORDER: COMPLETE ☐ PARTIAL ☐							TOTAL	

Spl 6-12-13

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: Dec 9, 2016
	P.O.# PO34379
	WEJAY JOB# 38320A

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-P1 'Standard Web'	20	Machined supplied extrusions complete per drawing req'ts	D3885 sheets 2-3 / rev. C

Note: 1) Material supplied by Dart Aerospace.
2) Inspection Reports attached.

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38320

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO34379

PART No. D3885-1P

DAS

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

Paul Rousen/ Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
--

DATE: Dec 1, 2016

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / **IN PROCESS** / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Ø .63"	18 places	+0.008/-.001		.632	1	Accepted
2	Hole, Ø 1.00"	13 places	+0.010/-.001		1.002	1	Accepted
3	Slot, R 0.50	2 places	+0.010/-.001		.501	1	Accepted
4	5.51"		± .03		5.516	1	Accepted
5	11.86"		± .03		11.858	1	Accepted
6	13.11"		± .03		13.106	1	Accepted
7	15.61"		± .03		15.603	1	Accepted
8	16.86"		± .03		16.852	1	Accepted
9	22.29"		± .03		22.288	1	Accepted
10	24.04"		± .03		24.035	1	Accepted
11	25.79"		± .03		25.783	1	Accepted
12	30.14"		± .03		30.123	1	Accepted
13	34.14"		± .03		34.125	1	Accepted
14	38.67"		± .03		38.658	1	Accepted
15	40.42"		± .03		40.407	1	Accepted
16	43.71"		± .03		43.699	1	Accepted
17	46.91"		± .03		46.895	1	Accepted
18	49.91"		± .03		49.897	1	Accepted
19	50.91"		± .03		50.899	1	Accepted
20	53.91"		± .03		53.900	1	Accepted
21	54.91"		± .03		54.900	1	Accepted
22	58.91"		± .03		58.898	1	Accepted
23	62.43"		± .03		62.421	1	Accepted
24	67.43"		± .03		67.420	1	Accepted
25	70.10"		± .03		70.084	1	Accepted
26	74.10"		± .03		74.086	1	Accepted
27	78.10"		± .03		78.086	1	Accepted
28	82.10"		± .03		82.086	1	Accepted
29	85.43"		± .03		85.422	1	Accepted

INSPECTION / TEST REPORT

JOB No. 38320

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO34379

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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30	88.01"		± .03		88.001	1	Accepted
31	92.01"		± .03		92.000	1	Accepted
32	96.01"		± .03		95.999	1	Accepted
33	100.01"		± .03		100.000	1	Accepted
34	103.43"		± .03		103.418	1	Accepted
35	108.42"		± .03		108.407	1	Accepted
36	109.67"		± .03		109.656	1	Accepted
37	112.17"		± .03		112.155	1	Accepted
38	113.42"		± .03		113.405	1	Accepted
39	113.92" o.a.		± .03		113.906	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.260	1	Accepted
41	R.03" TYP		± .03		.03	1	Accepted
42	R.02" TYP		± .03		.02	1	Accepted
43	3.358"		+0.010/-0.030		3.360	1	Accepted
44	R.13" TYP		± .03		.130	1	Accepted
45	.32" TYP		± .03		.320	1	Accepted
46	3.466"		+0.010/-0.030		3.470	1	Accepted
47	R.13" TYP		± .03		.130	1	Accepted
48	.080 TYP, REF		± .03		.080	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.383	1	Accepted
50	R.03" TYP		± .03		.03	1	Accepted
51	R.02" TYP		± .03		.02	1	Accepted
52	3.358"		+0.010/-0.030		3.356	1	Accepted
53	R.25" TYP		± .03		.250	1	Accepted
54	.32" TYP		± .03		.320	1	Accepted
55	R.25" TYP		± .03		.250	1	Accepted
56	3.428"		+0.010/-0.030		3.430	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.803	1	Accepted
58	R.03" TYP		± .03		.03	1	Accepted
59	R.02" TYP		± .03		.02	1	Accepted
60	3.246"		+0.010/-0.030		3.2455	1	Accepted
61	R.25" TYP		± .03		.250	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.985	1	Accepted
63	R.03" TYP		± .03		.03	1	Accepted
64	R.02" TYP		± .03		.02	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38320	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO34379							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.095	1	Accepted
66	R.25" TYP		± .03		.250	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.985	1	Accepted
68	R.03" TYP		± .03		.03	1	Accepted
69	R.02" TYP		± .03		.02	1	Accepted
70	3.026"		+ .010/- .030		3.032	1	Accepted
71	R.25" TYP		± .03		.250	1	Accepted
72	1.96"	Section G-G	± .03		1.970	1	Accepted
73	R.03" TYP		± .03		.03	1	Accepted
74	R.02" TYP		± .03		.02	1	Accepted
75	3.157		+ .010/- .030		3.159	1	Accepted
76	R.25" TYP		± .03		.250	1	Accepted
77	1.82"	Section H-H	± .03		1.830	1	Accepted
78	R.03" TYP		± .03		.03	1	Accepted
79	R.02" TYP		± .03		.02	1	Accepted
80	3.238"		+ .010/- .030		3.241	1	Accepted
81	R.25" TYP		± .03		.250	1	Accepted
82	1.48"	Section I-I	± .03		1.492	1	Accepted
83	R.03" TYP		± .03		.03	1	Accepted
84	R.02" TYP		± .03		.02	1	Accepted
85	3.358		+ .010/- .030		3.359	1	Accepted
86	R.25" TYP		± .03		.250	1	Accepted
87	3.396"		+ .010/- .030		3.400	1	Accepted
88	R.25" TYP		± .03		.250	1	Accepted



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38320

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO34379

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

Paul Rousen/ Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
--

DATE: Dec 6, 2016

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / **IN PROCESS** / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Ø .63"	18 places	+0.008/-0.001		.633	1	Accepted
2	Hole, Ø 1.00"	13 places	+0.010/-0.001		1.003	1	Accepted
3	Slot, R 0.50	2 places	+0.010/-0.001		.501	1	Accepted
4	5.51"		± .03		5.5135	1	Accepted
5	11.86"		± .03		11.855	1	Accepted
6	13.11"		± .03		13.104	1	Accepted
7	15.61"		± .03		15.603	1	Accepted
8	16.86"		± .03		16.852	1	Accepted
9	22.29"		± .03		22.289	1	Accepted
10	24.04"		± .03		24.038	1	Accepted
11	25.79"		± .03		25.787	1	Accepted
12	30.14"		± .03		30.130	1	Accepted
13	34.14"		± .03		34.133	1	Accepted
14	38.67"		± .03		38.666	1	Accepted
15	40.42"		± .03		40.415	1	Accepted
16	43.71"		± .03		43.707	1	Accepted
17	46.91"		± .03		46.904	1	Accepted
18	49.91"		± .03		49.906	1	Accepted
19	50.91"		± .03		50.906	1	Accepted
20	53.91"		± .03		53.907	1	Accepted
21	54.91"		± .03		54.907	1	Accepted
22	58.91"		± .03		58.905	1	Accepted
23	62.43"		± .03		62.431	1	Accepted
24	67.43"		± .03		67.430	1	Accepted
25	70.10"		± .03		70.094	1	Accepted
26	74.10"		± .03		74.094	1	Accepted
27	78.10"		± .03		78.093	1	Accepted
28	82.10"		± .03		82.092	1	Accepted
29	85.43"		± .03		85.428	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38320	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO34379							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	88.01"		± .03		88.008	1	Accepted
31	92.01"		± .03		92.008	1	Accepted
32	96.01"		± .03		96.009	1	Accepted
33	100.01"		± .03		100.009	1	Accepted
34	103.43"		± .03		103.427	1	Accepted
35	108.42"		± .03		108.416	1	Accepted
36	109.67"		± .03		109.665	1	Accepted
37	112.17"		± .03		112.164	1	Accepted
38	113.42"		± .03		113.412	1	Accepted
39	113.92" o.a.		± .03		113.912	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.259	1	Accepted
41	R.03" TYP		± .03		.03	1	Accepted
42	R.02" TYP		± .03		.02	1	Accepted
43	3.358"		+0.010/-0.030		3.356	1	Accepted
44	R.13" TYP		± .03		.130	1	Accepted
45	.32" TYP		± .03		.320	1	Accepted
46	3.466"		+0.010/-0.030		3.469	1	Accepted
47	R.13" TYP		± .03		.130	1	Accepted
48	.080 TYP,REF		± .03		.080	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.380	1	Accepted
50	R.03" TYP		± .03		.03	1	Accepted
51	R.02" TYP		± .03		.02	1	Accepted
52	3.358"		+0.010/-0.030		3.355	1	Accepted
53	R.25" TYP		± .03		.250	1	Accepted
54	.32" TYP		± .03		.317	1	Accepted
55	R.25" TYP		± .03		.250	1	Accepted
56	3.428"		+0.010/-0.030		3.430	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.797	1	Accepted
58	R.03" TYP		± .03		.03	1	Accepted
59	R.02" TYP		± .03		.02	1	Accepted
60	3.246"		+0.010/-0.030		3.245	1	Accepted
61	R.25" TYP		± .03		.250	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.985	1	Accepted
63	R.03" TYP		± .03		.03	1	Accepted
64	R.02" TYP		± .03		.02	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38320	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO34379							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.097	1	Accepted
66	R.25" TYP		± .03		.250	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.985	1	Accepted
68	R.03" TYP		± .03		.03	1	Accepted
69	R.02" TYP		± .03		.02	1	Accepted
70	3.026"		+ .010/- .030		3.034	1	Accepted
71	R.25" TYP		± .03		.250	1	Accepted
72	1.96"	Section G-G	± .03		1.950	1	Accepted
73	R.03" TYP		± .03		.03	1	Accepted
74	R.02" TYP		± .03		.02	1	Accepted
75	3.157		+ .010/- .030		3.162	1	Accepted
76	R.25" TYP		± .03		.250	1	Accepted
77	1.82"	Section H-H	± .03		1.805	1	Accepted
78	R.03" TYP		± .03		.03	1	Accepted
79	R.02" TYP		± .03		.02	1	Accepted
80	3.238"		+ .010/- .030		3.239	1	Accepted
81	R.25" TYP		± .03		.250	1	Accepted
82	1.48"	Section I-I	± .03		1.480	1	Accepted
83	R.03" TYP		± .03		.03	1	Accepted
84	R.02" TYP		± .03		.02	1	Accepted
85	3.358		+ .010/- .030		3.362	1	Accepted
86	R.25" TYP		± .03		.250	1	Accepted
87	3.396"		+ .010/- .030		3.399	1	Accepted
88	R.25" TYP		± .03		.250	1	Accepted